

Date: Wednesday, 1/11/2006 4:21:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 25441F		
Estimate Number	: 10287		
P.O. Number	: N/A	Part Number	: D32021
This Issue	: 1/11/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3202 REV B1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24267F	Drawing Revision	: B1
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/18/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	20
Comment	: Est Rev:B No Longer Made In House 05-11-06 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 398

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg

Possible supplier: Ind. Laser

Material release note is required.

W 06.01.20. (20)

2.0

D32021F

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cover

cf 06/03/09 (20)

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

cf 06/03/09 (20)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.03.15 20

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Debur

540 06.03.26 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:21:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 25441F

Part Number: D32021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/04/02

(20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m 06-04-03

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MM

06 04 03

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 86

24/4/5 (20)

Job Completion



Inspection

Level 21

(20)

06/04/06

06/04/05

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

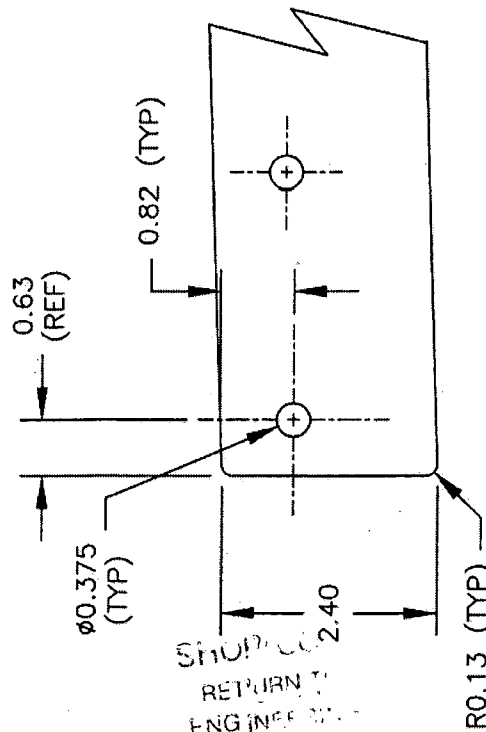
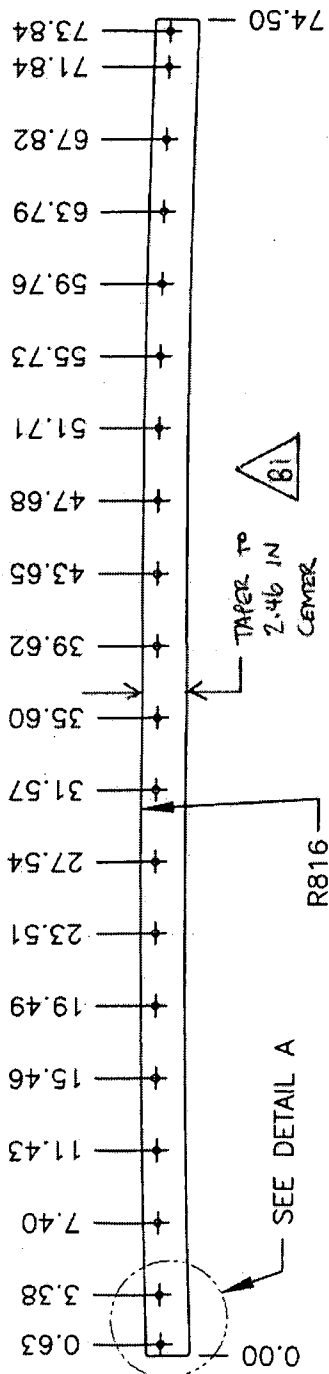


DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3202	SHEET 1 OF 1
DATE	03.10.16	TITLE	COVER	SCALE	1:10
A	01.01.01	NEW ISSUE			
B	03.10.16	REDESIGN; PART NOW CURVED			
BI	<i>CP</i> 04.05.14	CLARIFY MID-SPAN DIMENSION			

RELEASED

03.11.07 *[Signature]*

DETAIL A
SCALE 1:2



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 25441F

D3202-1 COVER

- 1) MATERIAL: 5052-H32/H34 SHEET (Q0-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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ntegris

METALS

Packing List Shipping Order

MO #

12311 HORSESHOE WAY
12311 HORSESHOE WAY
Phone: (604) 272-2422

RICHMOND BC V7A 4X6
RICHMOND BC V7A 4X6

Page 1 of 1 02/21/06 18:37 CST
SO AP

Order Number

90-373971

Purchase Order

110871

SOLD TO:
INDUSTRIAL LASER CUTTING LTD
#7 - 7504 VANTAGE PLACE
PHONE: 604 946 4152
DELTA

SHIP TO: Phone: (604) 946-4152
INDUSTRIAL LASER CUTTING LTD
C/O CIKING PROFILES INC 604 821 0773
14471 KNOX WAY
RICHMOND BC V5V 2Z1

Total Packages: 1

Ship Via	Freight	Customer #	Sales	Tax Status	Contact	Certs	Due Date
STRAIT EXPRESS	FOB Warehouse Collect	443322	6 CD	TAXABLE		1	02/22/2006
Bill of Lading:	Pro Bill:	Ship Approval:	Ship Date:	Order Date:			
				02/21/2006			

Line No.	Item	Description	Qty Shipped	B/O Quantity
1	5458-2572	AL SHT TL QQA250/8 5052H32 .032 X 48 X 96		
Qty Comm: 3 SHTS	Order Qty: 3	UEA	Pcs: 3	3.00 UEA
(1 -SKID 83 4X8)				

Cntrl: 90277428 H: 467071

T: 467071

3 pcs Loc PEND

Wt: 43

PLS SHIP STRAIT EXPRESS COLLECT

*** FILLED BY INITIALS: PD

P.O: 398

Customer/Driver Instructions:
WILL TEST REPORTS REQUIRED ALL SHIPMENTS

Received by: _____ Date: _____
Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at www.integrismetals.com
(or from your sales representative, or by calling (800) 328-7800).

PACKING LIST

Alloys of Aluminum, Copper, Steel Caution:
Processing of this material may present a physical and or health hazard. See material safety data sheets for further information

MATERIAL TEST REPORT

From: PECHINEY ROLLED PRODUCTS
CENTURY ROAD
P.O. BOX 68
RAVENSWOOD, WV , 26164

Page : 1
Heat/Lot : 467071
TIN : 467071

Sold To: INTEGRIS METALS, LTD.
12311 HORSESHOE WAY
RICHMOND , BC V7A 4X6

Ship To: 2306 "B" STREET NW
AUBURN WA
98002

Vendor Information

Cust. PO #: 20991

Cust. PO DT: 01/08/06

Specifications

RAVENSWOOD DISTRIBUTOR
SPEC COIL, NON HT MILL
AMS-QQ A 250/8
ALSO CONFORMS TO ASTM B209-04
Buyer Part: 54582309
5052 H32 .032 IN 48 IN

James

Mechanical Tests

	Min	UOM	L	O	Max	UOM	L	O
Number of Tests: 2								
Ult Tensile Str, Longitudinal	34.6	KSI	LONG		35.4	KSI	LONG	
Yield Strength	28.3	KSI	LONG		29.6	KSI	LONG	
Elongation, Longitudinal	9	PCT	LONG		9.5	PCT	LONG	

Chemical Composition

SI Silicon Pct	.130	FE Iron-Pct	.340
CU Copper-Pct	.040	MN Manganese-Pct	.030
MG Magnesium Pct	2.340	CR Chromium-Pct	.190
ZN Zinc-Pct	.020	OE Others Each Max-Pct	.050
OT Others Tot Max-Pct	.150	Al Remainder-Pct	

Comments

MATERIAL TEST REPORT

From: PECHINEY ROLLED PRODUCTS
CENTURY ROAD
P.O. BOX 68
RAVENSWOOD, WV , 26164

Page : 2
Heat/Lot : 467071
TIN : 467071

CERTIFICATION

Pechiney Rolled Products / International Corporation

certifies that metal shipped under this order has been inspected and tested and found in conformance with the requirements of the applicable specifications as indicated herein. any warranty is limited to that shown on PRP(s) standard General Terms and Conditions of Sales. Test reports are on file, subject to examination

PECHINEY ROLLED PRODUCTS

RAVENSWOOD OPERATIONS - RAVENSWOOD, WV. 26164

QA by MARK PARSONS 10/27/2005

Miscellaneous Data

Control #: 90277428

Date: 02/21/06

S.O. Number : 590 373971 1

AL SHT TL QQA250/8 5052H32

.032 X 48 X 96

Customer P.O.: 110H71

The Chemical Analysis and Mechanical Test data was received via EDI from the above mentioned vendor.

INTEGRIS METALS, LTD.